

Work Order ID 132230

Monday, May 04, 2015 11:42:19 AM

132230

Page 1

Item ID: D5145-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bar

Stop

NS2

Start Date: 5/4/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/4/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: MAY 04 2015

Tooling:

Date: _____

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5145	A

110 0.00

110

Cold Saw

Memo

Hyd Mech

CUT D5145-1 TO SIZE AS PER DWG

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

Quality Control

130 Identify as per dwg & Stock Location: WA001 0.00

130

Packaging

Memo

Packaging

LOCATION: WA001

15-05-04
JPL

4

DAS
50
9-89

DAS
38
9-89

4

15-5-4

4

15-05-04
JPL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 132230***132230***

Page 2

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Item ID: D5145-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 5/4/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/4/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

~~MCS MAY 14 2015~~
MCS MAY 15 2015

MF
15-5-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, May 04, 2015 11:42:22 AM

Page 1

Work Order ID: 132230

132230

Parent Item: D5145-1

D5145-1

Parent Item Name: Bar

Start Date: 5/4/2015

Required Date: 5/4/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.11.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased			No		f	141.5760		13			

M304B0 250x0 500

304 BAR .250 x .500

15-05-04

JBL

Location

Loc Qty

Loc Code

MAT009

~~132230~~

141.576

m129366

28.696

m131205

7.25

m131748

105.63

1/4.83

DQA: _____ Date: _____

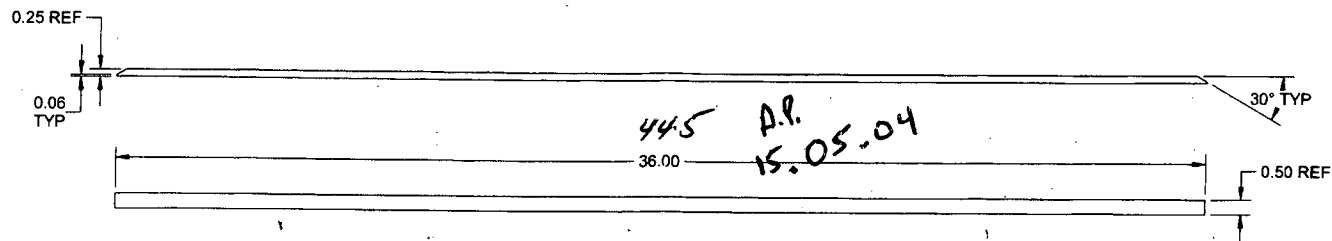


WORK ORDER NON-CONFORMANCE / UPDATE

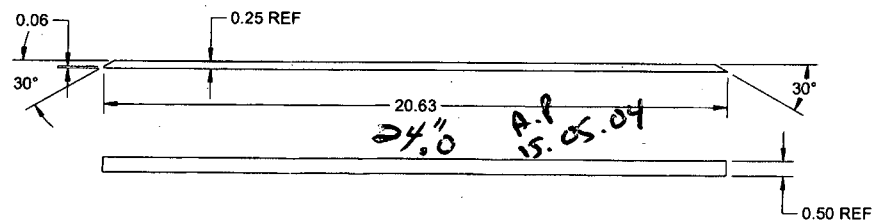
QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																



D5145-1 BAR



D5145-3 BAR

SEE COPY
TO
FROM
LEAD COPY
MOUNT
OF
132230 MLC

MAY 04 2015

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT: D5145-1= 1.27 lbs, D5145-3= 0.72 lbs

APPROVED

A		NEW ISSUE		DB	14.08.21
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA			
DRAWN	DB				
CHECKED	ML	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5145	SHEET 1 OF 1		
APPROVED	MP	TITLE	SCALE		
DE APPR.	DS	BAR	NTS		
DATE	14.08.21				

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RELEASED
2014-11-10
W

DQA:

Date: 15/05/26



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/05/15

Work Order update only ☐

Work Order: <u>132230</u> Part No. <u>DS145-1</u> NCR No. <u>15-4965</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																																											
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